

Date: Tuesday, 10/30/2007 2:48:33 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG BRACKET
Job Number : 35434	
Estimate Number : 10010	
P.O. Number : N/A	Part Number : D27353
This Issue : 10/30/2007 S.O. No. : N/A	Drawing Number : D2735 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 34920	Material : N/A
Written By : <u>JA</u>	Due Date : 11/6/2007 Qty: 50 Um: Each
Checked & Approved By : <u>JA 07 10 31</u>	
Comment : Est Rev: C Removed from 9 Digit 05-10-25 JLM	
Est. C 06.07.21 waterjet EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S125	1010-1025 sheet .125
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10.2247



Comment: Qty.: 0.1733 sf(s)/Unit Total : 8.6625 sf(s)

1010-1025 sheet .125

batch: 106140 IB 07-11-7

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2735

Dwg Rev: C

Prog Rev: C

IB 07-11-7

2-Deburr if necessary

IB 07-11-7

(59)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 07-11-7



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

CA 11/1/07 (59) county

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204

2-Deburr if required.

SB 08/01/02/02 (59)

08/01/03 (59)

(59)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/30/2007 2:48:34 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 35434

Part Number: D27353

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



corrects

Comment: INSPECT WORK TO CURRENT STEP

5 08/01/08 (59)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CVS

FC 08 01 08

(59)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(59)

Comment: FINAL INSPECTION/W/O RELEASE

12/08/01/08

Job Completion



mi 2008/1/18

W

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

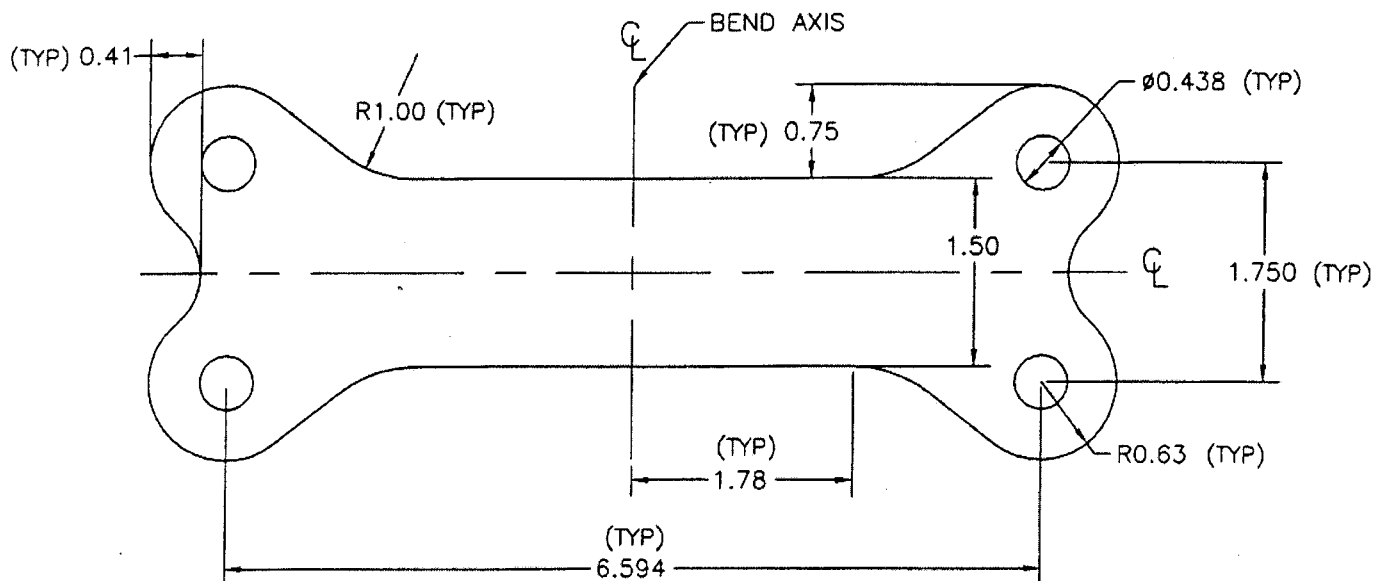
**NOTE:** Date & initial all entries



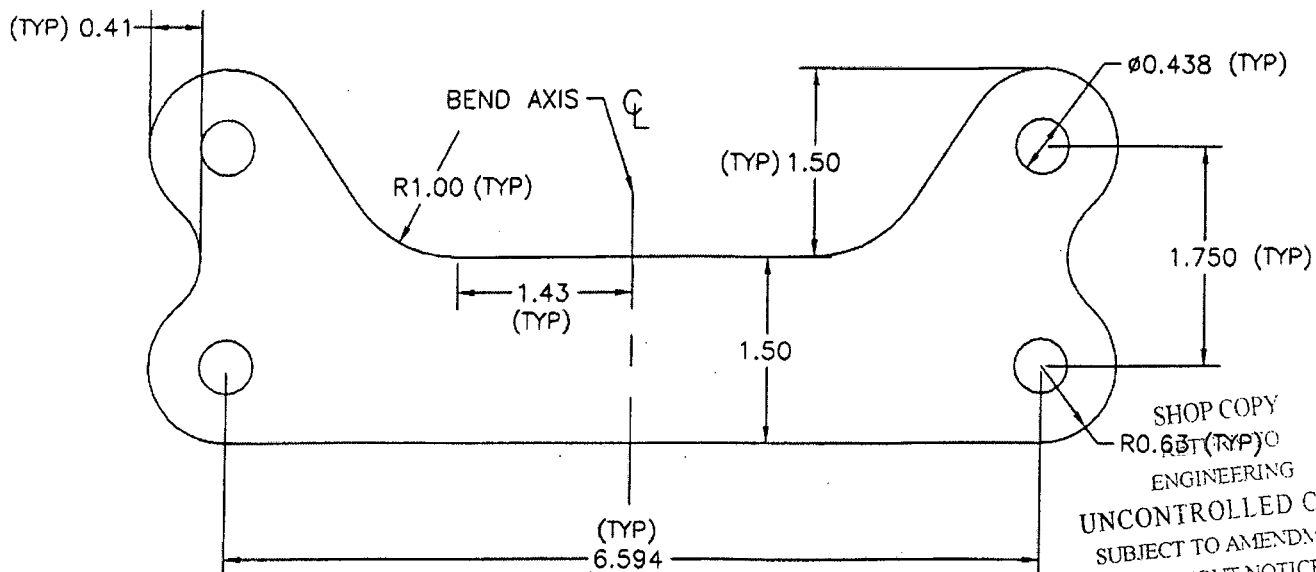


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2735	REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED  
98.12.14 DS



D2735-1 FLAT PATTERN  
SYMMETRIC ABOUT BOTH CENTRE-LINES (CL)



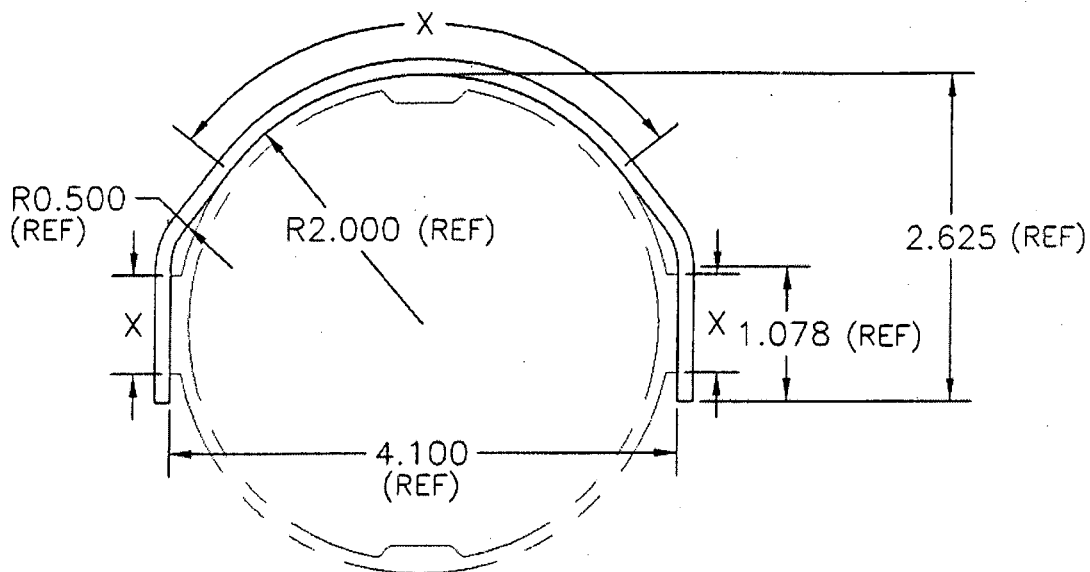
D2735-3 FLAT PATTERN  
SYMMETRIC ABOUT CENTRE-LINE (CL)

SHOP COPY  
R0.63 (TYP)  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35434



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED  
98.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL  
0.125 THICK (11 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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WORK ORDER  
NO. 35434